

Work Order ID 124931

September-26-14 11:49:03 AM

124931

Page 1

Item ID: D4711-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Expandable Pin Assembly, Modified **3**
 Start Date: 9/26/14 Start Qty: ~~2.00~~ ***2*** Cust Item ID:
 Required Date: 10/03/14 Req'd Qty: 2.00 ***2*** Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4711	C

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	ASSEMBLE AS PER DWG (see note 8,9,10)								
	DO NOT OVERTIGHTEN THE SHAFT INTO THE BARREL PER NOTE 10								

130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

3 FF OCT 20 2014
 3 FF OCT 20 2014
 (3) DAS 51 14/10/20
 14/10/20

Work Order ID 124931***124931***

Page 2

September-26-14 11:49:03 AM

Item ID: D4711-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Expandable Pin Assembly, Modified
Start Date: 9/26/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 10/03/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>St 117</u>	0.00				(3)	14/10/21		DAS 46 9-89
140	Packaging	0.00							
Packaging	Memo								
150	QC21- Final Inspection - Work Order Release	0.00							
150	QC	0.00							
Quality Control									

14/10/21 *[Signature]*
[Signature] 4-10-21

Picklist Print

September-26-14 11:49:02 AM

Page 1

Work Order ID: 124931

124931

Parent Item: D4711-041

D4711-041

Parent Item Name: Expandable Pin Assembly, Modified

Start Date: 9/26/14

Required Date: 10/03/14

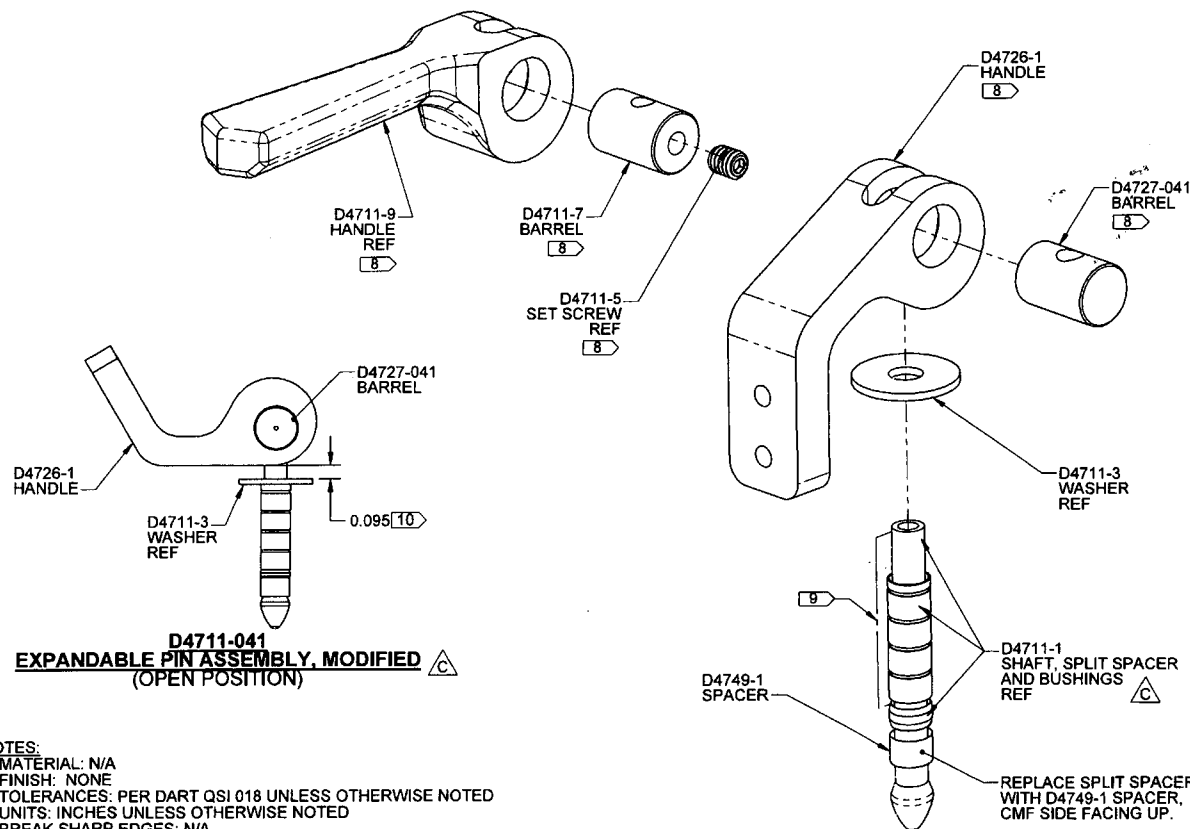
Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:B
13.03.11 AS PER DWG REV.C DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4711-043		Manufactured	No			110	Each	23.0000	1	2			
D4711-043									**		FF	OCT 20 2014	
Expandable Pin Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST117				23					
				113418				23		3			
D4726-1		Manufactured	No			110	Each	17.0000	1	2			
D4726-1									**		FF	OCT 20 2014	
Handle													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST119				17					
				113414				5					
				117218				12		3			
D4727-041		Manufactured	No			110	Each	29.0000	1	2			
D4727-041									**		FF	OCT 20 2014	
Barrel													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST119				29					
				113415				9					
				116091				20		3			
D4749-1		Manufactured	No			110	Each	59.0000	1	2			
D4749-1									**		FF	OCT 20 2014	
Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST119				59					
				113419				10		3			
				114888				49					

ITEM	QTY	P/N	DESCRIPTION
	X	D4711-041	EXPANDABLE PIN ASSY, MODIFIED
1	1	D4711-043	EXPANDABLE PIN ASSY
2	1	D4726-1	HANDLE
3	1	D4727-041	BARREL
4	1	D4749-1	SPACER



**D4711-041
EXPANDABLE PIN ASSEMBLY, MODIFIED
(CLOSED POSITION)**

**D4711-041
EXPANDABLE PIN ASSEMBLY, MODIFIED
(OPEN POSITION)**

NOTES:

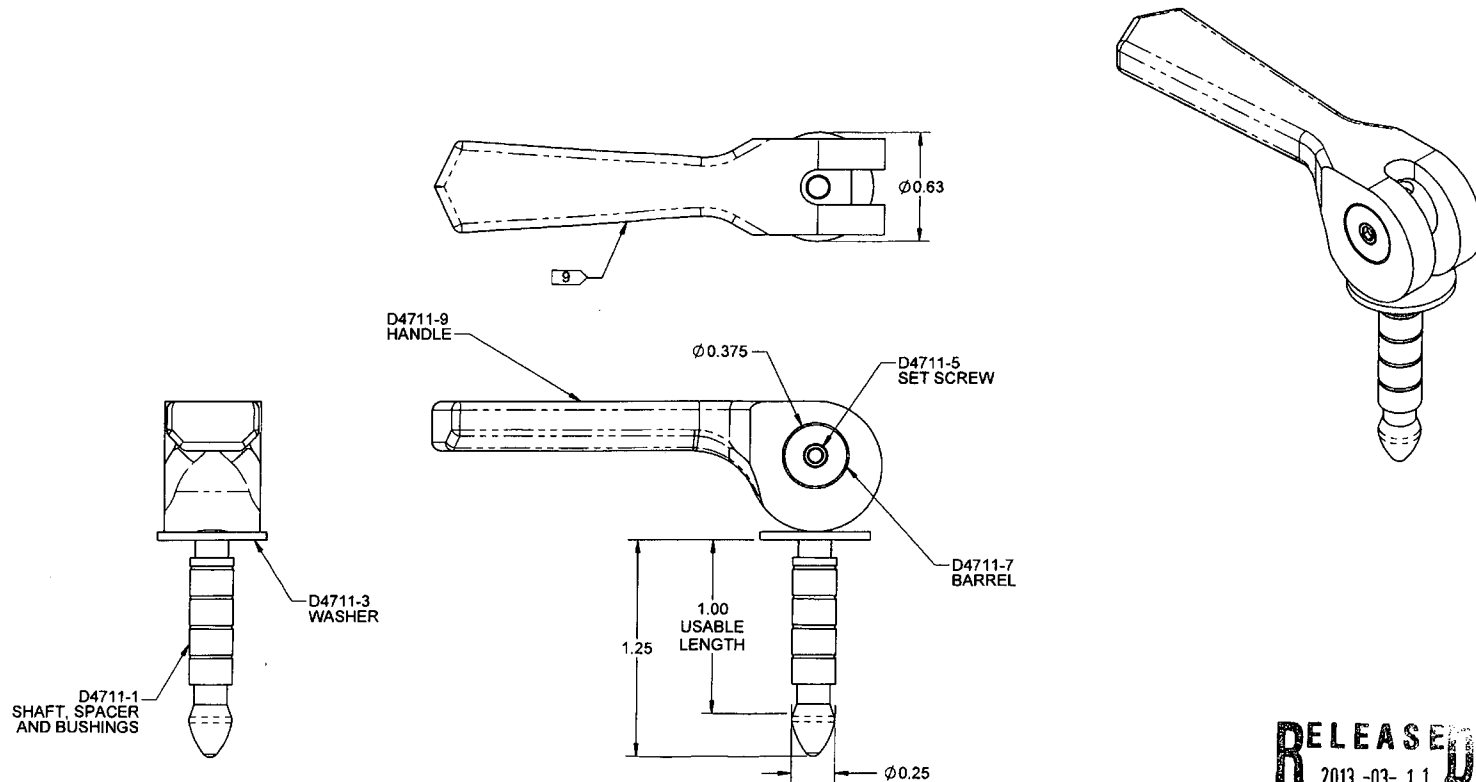
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4711-041" AND B/N "BXXXXX" PER QSI 044 6.7
- 7) WEIGHT: 0.19 lbs
- 8) REPLACE D4711-9 HANDLE WITH DART D4726-1 HANDLE.
REPLACE D4711-7 BARREL WITH DART D4727-041 BARREL.
REPLACE BOTTOM SPLIT SPACER WITH D4749-1 SPACER.
DISCARD D4711-5 SET SCREW, D4711-7 BARREL, D4711-9 HANDLE, BOTTOM SPLIT SPACER.
- 9) WHEN INSTALLING D4749-1 SPACER, ENSURE THAT ALL RETAINED SPLIT SPACERS AND BUSHINGS REMAIN IN THEIR ORIGINAL SEQUENCE AND ORIENTATION.
- 10) INSTALL THE D4711-1 SHAFT WITH THE ASSEMBLY IN THE OPEN POSITION, UNTIL A GAP OF 0.095" EXISTS BETWEEN THE D4711-3 WASHER AND THE D4726-1 HANDLE. DO NOT OVERTIGHTEN THE SHAFT INTO THE D4727-041 BARREL.

C	REVISED NOTE (A4-1) & NOTE 8. ADDED NOTE 10. PICTORIAL UPDATE. ADDED VIEW B8-1.	AP	13.02.12
B	ADDED D4749-1 SPACER, MODIFIED NOTES 8 AND 9	AP	12.11.23
A	NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D4711	SHEET 1 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	ADJUSTABLE DIAMETER PIN	NTS
DATE	13.02.12	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2013-03-11

124931

SPECIFICATION CONTROL DRAWING



D4711-043 EXPANDABLE PIN ASSY

NOTES:

- 1) MATERIAL: CORE PIN, SPLIT RINGS & BARREL: STAINLESS STEEL 17-4 PH CONDITION H925 PER AMS 5843
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs
- 8) RECOMMENDED SUPPLIER: MCMASTER CARR P/N 97787A661
- 9) HANDLE, BARREL AND SET SCREW TO BE DISCARDED AT NEXT HIGHER ASSEMBLY

RELEASED
2013-03-11

DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D4711	SHEET 2 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	ADJUSTABLE DIAMETER PIN	NTS
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